

159714

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Start Date: 4/18/2017 **Start Qty:** 20.00 ***20***

Cust Item ID:

Required Date: 5/3/2017 **Req'd Qty:** 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: _____ Date: APR 18 2007

Tooling: _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3910	E								
110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to Metec : <u>35992</u> Machine as per dwg C of C is required								
						20	APR 18 2017		DAS 13 9-89
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.40							
Packaging	Ensure C of C is attach								
						20x	SPI752		
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control						20	MAY 29		DAS 38 9-89 401

Work Order ID 159714

Tuesday, April 18, 2017 11:24:52 AM

159714

Page 2

Item ID: D3910-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Crosstube Lug
Start Date: 4/18/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 5/3/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.67							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.20							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:43.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ <i>N/A</i> <i>DAS 38 9-89</i>	0.00 0.38							

Tuesday, April 18, 2017 11:24:52 AM

Page 3

NS1

Stop *NS2*

Reference:

NR1

Stop ***NR2***

**Insp.
Stamp**

DAS
38
9-89

MAY 29 2017

DAS
6
9-89

MAY 30 2017

2.00

DAS
21
9-89

MAY 30 2017

Picklist Print

Tuesday, April 18, 2017 11:24:51 AM

Page 1

Work Order ID: 159714

159714

Parent Item: D3910-3

D3910-3

Parent Item Name: Crosstube Lug

Start Date: 4/18/2017

Required Date: 5/3/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3910-3P		Purchased	No			110	Each	0.0000	1	20			
D3910-3P									**				
Crosstube Lug													
D2423		Manufactured	No			110	f	326.9190	0.13	2.736842			
D2423									**				
Lug Extrusion													

20X SP17-5-23

APR 18 2017

DAS
13
8-89

Location

Metec

127892

148835

Loc Qty

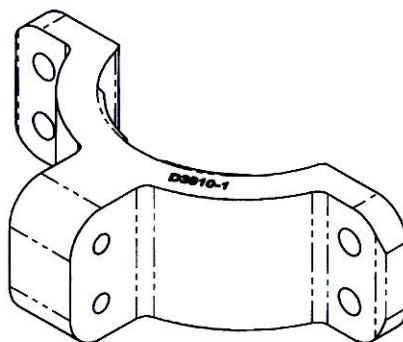
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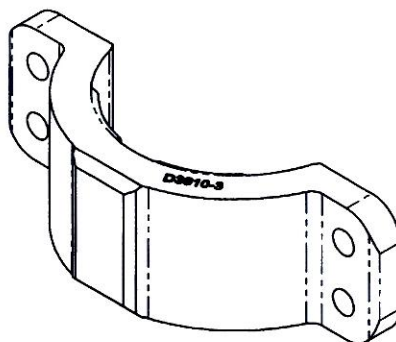
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Loc Code

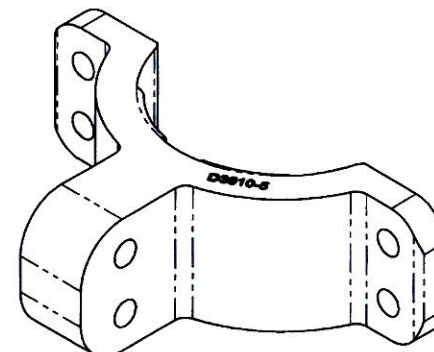
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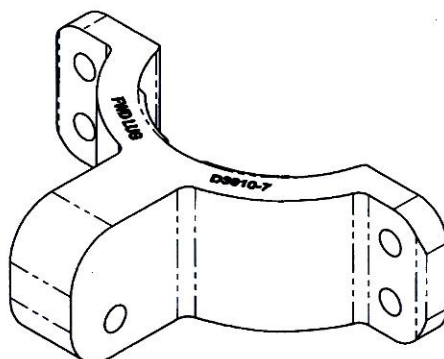
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

DAS
13
9-89

APR 18 2017

W10:159714

RELEASED

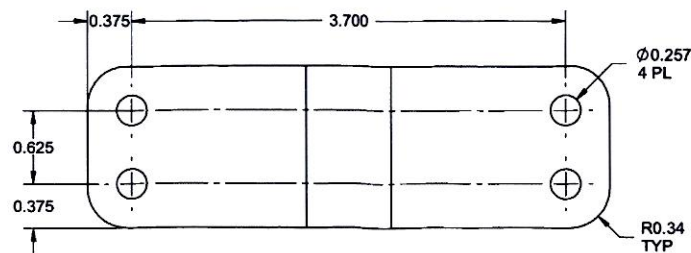
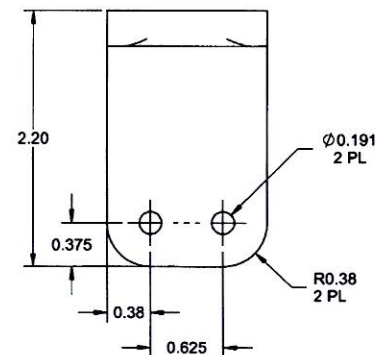
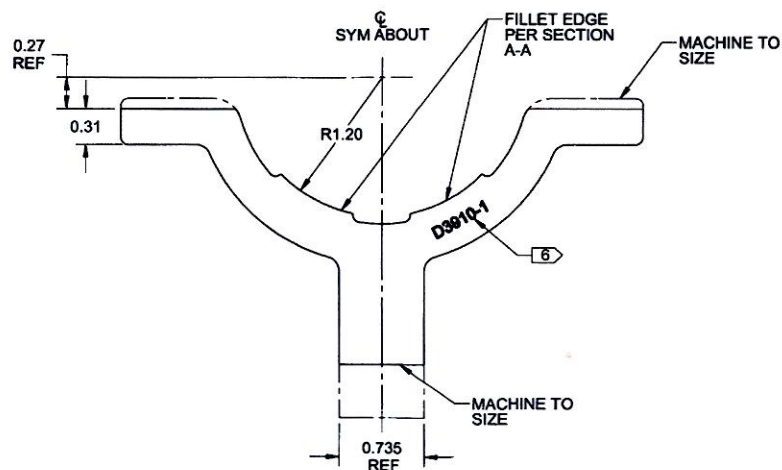
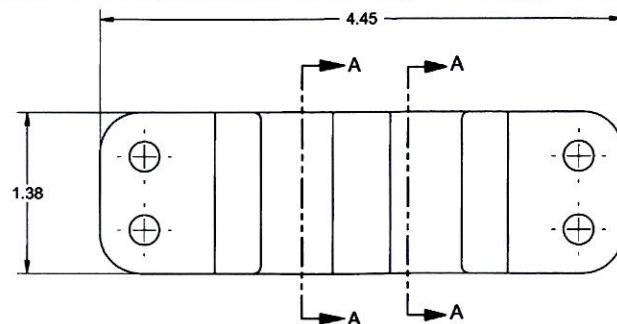
2014 JUN 05
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D392-597-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	AJS	D3910	SHEET 1 OF 5
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG

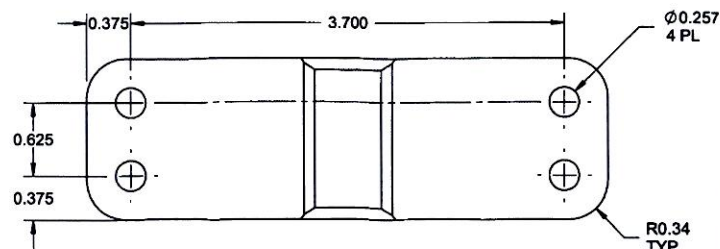
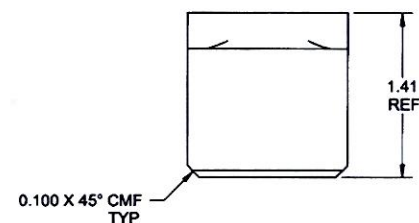
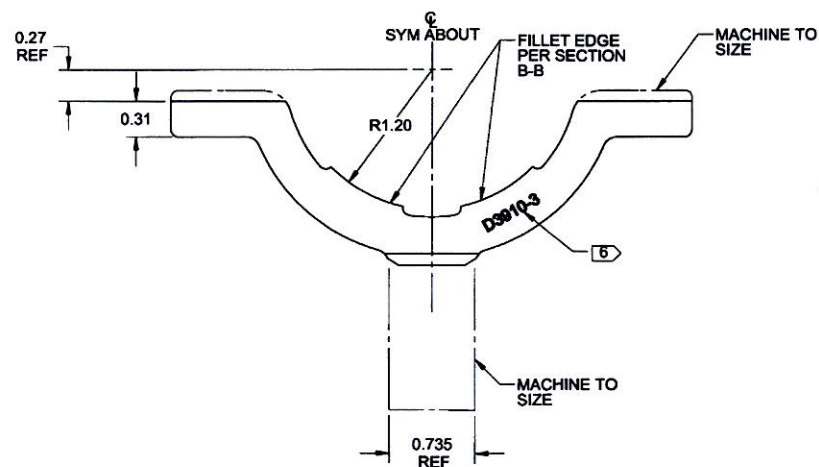
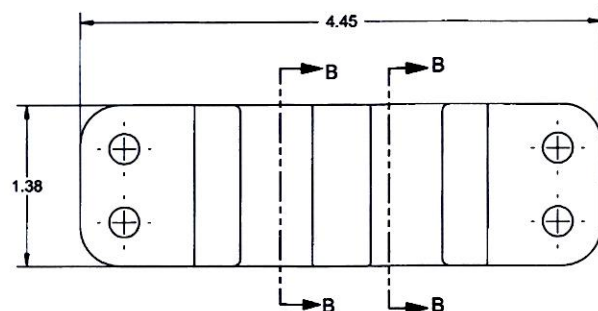
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DE APPR.	<i>[Signature]</i>		
DATE	14.05.16		



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

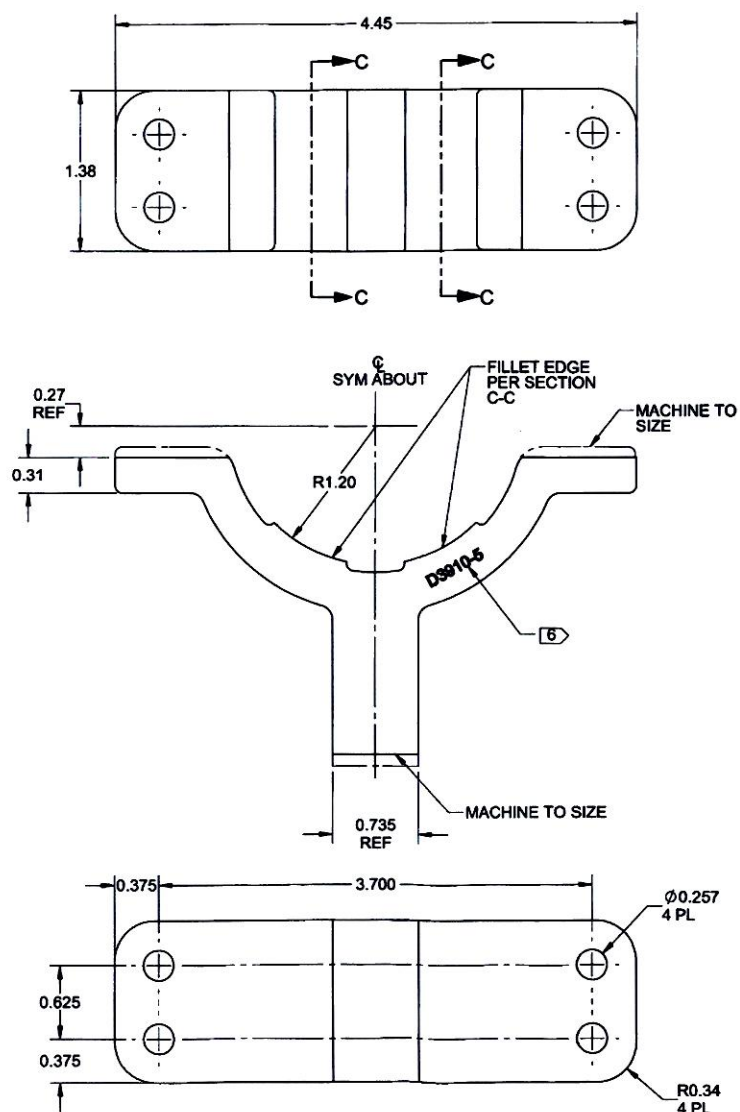
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2014 JUN 05

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DATE	14.05.16		

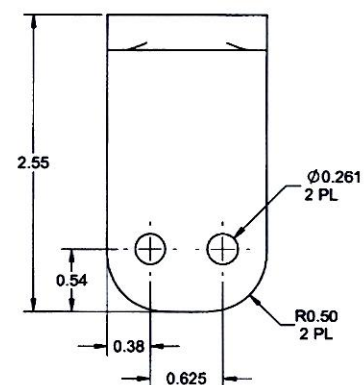
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



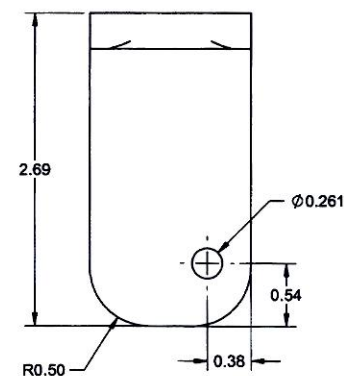
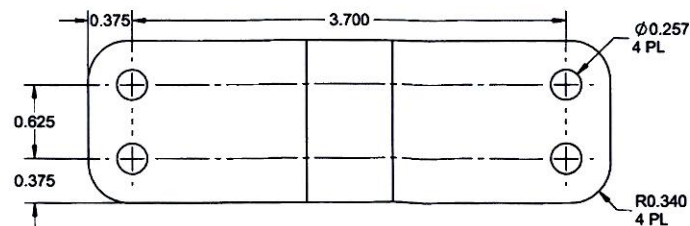
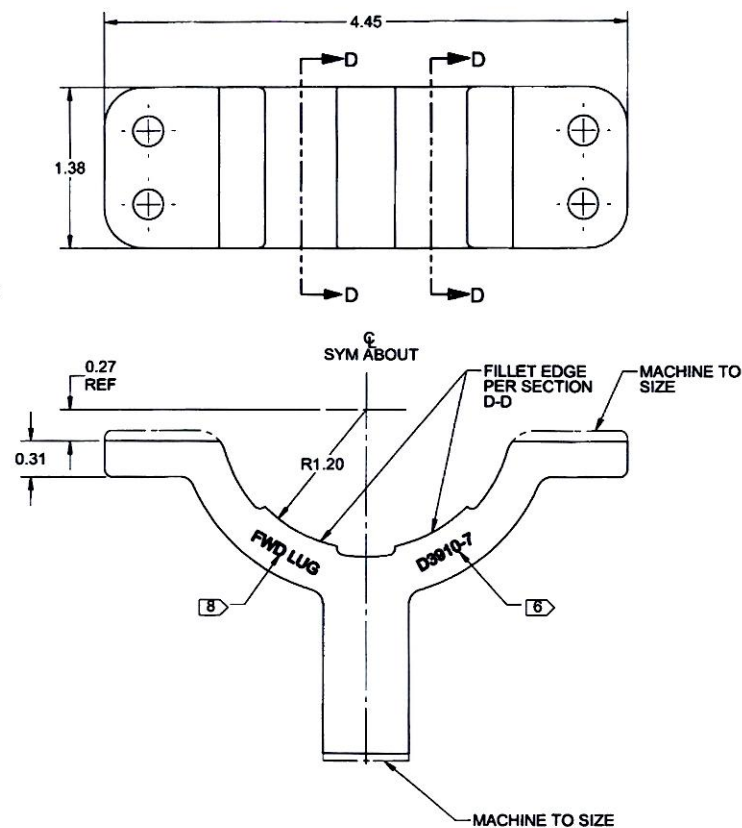
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2014 JUN 05

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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3910	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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SECTION D-D



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



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2014 JUN 05

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CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35992

Purchase Order Date 4/18/2017

PO Print Date 4/18/2017

Page Number 1 of 2

Order From :

VC-MET003

Ship To : DART AEROSPACE LTD

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

APR 18 2017

Contact Name

Vendor Phone

613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Dart Truck

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 10

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D3910-3P	Crosstube Lug	5/3/2017 Yes 5/3/2017		20.00 Each	\$16.10	\$322.00
	AS PER DWG D3910 REV. E B159714 ALODINE AND PAINT AS PER QSI 005						
						Line Total:	\$322.00
2	D3910-5P	Crosstube Lug	5/3/2017 Yes 5/3/2017		20.00 Each	\$16.10	\$322.00
	AS PER DWG D3910 REV. E B159715 ALODINE AND PAINT AS PER QSI 005						
						Line Total:	\$322.00

Note:

4/18/2017



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21696
Date: May 18, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 35992	Sold By: Walz, Christian D.
Shipped By: your truck	Ship Date: May 18, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-3 Crosstube Lug Alodine and Paint as per QSI 005	Each	20	20	
D3910-5 Crosstube Lug Alodine and Paint as per QSI 005	Each	20		
D3910-7 Crosstube Lug, as per drawing D3910 Rev.E Alodine and Paint as per QSI 005	Each	20		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by <u>SPT-5-23</u>		Thank you for your order! DAS 38 9-86		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Paint Batch #	P.O. Number
✓ 20	D3910-3 ✓	Crosstube Lug	21012	35992

MATERIAL: supplied by DART B148835

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 18, 2017